Work Ord April 24-14 9:0		7040					Pag	де 1						
Item ID: Revision ID:	D3393-041		-		Accept	*N900	040	100)*	Setup	Start	*/	 1.5.1 ×	t
Item Name:	Battery Lock										Stop	*N	152*	t
Start Date:	4/23/14	Start Qt	ty: 2.00	*2*		Cust Item	ID:							
Required Date	: 4/23/14	Req'd Q	ty: 2.00	*2*	ų.	Customer:							,	
Reference:				_							_			
Approvals:	Process Pla	in: ML	2	Date: 14-04-	Z Tooling:	D	ate:	_		Run	Start	*N	R1*	k
•	QC:			Date:	SPC (Y/N):		ate:				Stop	*NR2*		
Sequence ID/ Work Center I	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej		Reject Number	Insp. Stamp)
Draw Nbr	Rev	ision Nbr												
D3393	Rev	A												
*100 *100*		Small Fab			0.00			DAS 30	7					140
Small Fab			Memo		0.00			9-89						
Small Fab			1-Open D3 and lock ba per Dwg D3	373-1 lock package. Kee arrel. Discard the rest.2-U	E OR KEYED DIFFEREN's p keys, lock body, lock body, lock body, lock body, sing the flat cam, fabricate 3-Assemble D3393-041 as	dy nut, flat cam e D3369-5 as								
110					0.00									
1 1 0		Large Fab			0.00				2) 14	1-0P-	12	dq	

Tack Weld lock shaft to flat cam of a Max 1/8" Long OtyPart Number Description Batch A/RN/A SS Rod HU3333

Large Fab

DQA:			Date:			,							•	TRAC		
						WORK ORDER NON-	-CC	ONFORMANCE / UPDATE								
QA Closed:			Date:							V	Vork Order	update only				
Work Orde	ır.					DISPOSITION										
WOIK OIG	-					Rework	ı 1		Skid-tube	Crosstube	7	Water Jet		Engineering		
Part N	lo.					Scrap			Machining	Small Fab	Prod. Eng. Coor.			Quality		
	_	11			_	Use-as-is			noforming	Finishing		tore/Packaging	П	Other		
NCR No.					_	Suspected Unapproved						Supplier				
Root					Descr	ription of work order update		nitial	Actio	on	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	Date	Verificatio	n	QC Inspector		
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		Bending ¹	•			Bend		1	Program			imensions	${f -}$	Pressure/Forced		
		Centre No	t Concer	ntric		BOM/Route	<u> </u>	Grain		<u> </u>		ler tolerance	—	Set-up		
	-	Cracks				Broken/Damage/Defect		Hardwa			Part Inco		-	Temperature/Cure		
	Crimp/Kink/Ripple/Wave					Burrs		1 '	tion Incomplete/Und	·	Part Lost/		$\boldsymbol{\vdash}$	Weld		
	Cuffs					Contamination	<u> </u>	4	tions Incomplete/Ur	nclear	Part Mov			Wrong Stock Pulled		
	Crushing				<u> </u>	Countersink		-	gned/off center		Positione	=				
	Heat Treat				<u> </u>	Cut Too Short		Mislab			Power Lo	ss/Surge	Ш	Other		
	Inspection Strip in Tube					Drawing	<u> </u>	Misrea								
	-	Marks/Ch				Drill Holes		Off-set								
	Turning Sequence					Finish		4	Calibration			· · · · · · · · · · · · · · · · · · ·				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence							

0.00

Memo

140

Quality Control

DQA:			Date:			•			_					TRAC"
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT				_	AEROSPACE
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Work Orde	r:					DISPOSITION			AC	GAINST DE	PARTMENT	PROCESS		
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	-					Use-as-is			· —	inishing	ŧ	e/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab Com	nposite]	Supplier		
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Transport	\neg													
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Landir	ng G	iear		·-		General					_			
[Bending				Bend		Folio/F	Program		Outside Dim	ensions	\blacksquare	Pressure/Forced
		Centre No	ot Concen	ntric		BOM/Route	L	Grain		<u> </u>	Over/Under			Set-up
	_	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorred		\dashv	Temperature/Cure
]]	-	Crimp/Kir	nk/Ripple,	/Wave		Burrs	_	1	ion Incomplete/Unqualif		Part Lost/Mi	ssing	\vdash	Weld
]	Cuffs					Contamination		-i	tions Incomplete/Unclear	r	Part Moved		Ш	Wrong Stock Pulled
	-	Crushing				Countersink	L	-	gned/off center	<u> </u>	Positioned V	_	$\overline{}$	Oak
	_	Heat Trea		 .	\vdash	Cut Too Short	\vdash	Mislab			Power Loss/	Surge		Other
	\dashv	Inspectio	-	Tube	\vdash	Drawing	\vdash	Misrea						· · · · · · · · · · · · · · · · · · ·
	\neg	Marks/Ch			\vdash	Drill Holes	\vdash	Off-set						¥
1	-	Turning S			\vdash	Finish	-	4	Calibration					
		Wave/Tw	ist in Lub	e	L	Fit/Function	<u> </u>	Out of	Sequence			<u> </u>		

Page 3

Work Order ID 117040 *117040* April-24-14 9:09:54 AM Item ID: D3393-041 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name: Battery Lock** *9* Start Oty: 2.00 Start Date: 4/23/14 **Cust Item ID:** Required Date: 4/23/14 Reg'd Oty: 2.00 *9* **Customer:** Reference: Start Run Process Plan: Date:_____ **Tooling:** Approvals: Date: Stop Date: QC: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description Qty Oty Number Stamp **Run Hours** Code 150 Identify as per dwg & Stock Location: 5T 0.00 DAS *150* 28 Packaging 0.00 Memo Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

Quality Control

OC

Memo

0.00

MLJ 14-00-12 MY 14-6-12

Insp.

JUN 1 2 2014

DQA:			Date:			144004 00050 1401	WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFOI	RMANCE / UPDAT		ork Order up	odate only	AER OSPĀCĒ			
						DISPOSITION			AG	GAINST DE	PARTMENT	/PROCESS				
Work Orde	er: _					[. 1				,					
Part N	No					Rework Scrap		Skid-tube Crosstube Machining Small Fab				Water Jet d. Eng. Coor	Engineering Quality			
NCR No.					Use-as-is Suspected Unapproved		Thern	~ 	nishing nposite	Rec/Stor	e/Packaging Supplier	Other				
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Landi	ng G	ear				General		,								
	1	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced			
		Centre No	t Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up			
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	i	Temperature/Cure			
	\Box	Crimp/Kin	k/Ripple	/Wave		Burrs '		Inspect	ion Incomplete/Unqualifi	ied	Part Lost/Mi	ssing	Weld			
	Cuffs					Contamination		Instruct	tions Incomplete/Unclear	r	Part Moved		Wrong Stock Pulled			
	Щʻ	Crushing				Countersink		Misalig	ned/off center		Positioned V		-			
Heat Treat				<u> </u>	Cut Too Short		Mislabe			Power Loss/	Surge	Other				
	Inspection Strip in Tube					Drawing		Misread								
;						Drill Holes		Off-set								
						Finish		4	Calibration							
	Wave/Twist in Tube					Fit/Function		Out of S	Sequence							

April-24-14 9:09:56 AM

Work Order ID: 117040

117040

Parent Item:

D3393-041

D3393-041

Parent Item Name: Battery Lock

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
^{116WC} *5/16WC*		Purchased	No			100	Each	459.0000	2 **	4	DA:)	14(06/
asher				Location		Loc		Loc Code			9-8	9	
				ST365	M127961		459 459		_	4	_		
567K21 9567K21*		Purchased	No	-		100	Each	9.0000	2 **	4	_	DAS 30 9 8 9	146
lyetheline Cap				Location		Loc		Loc Code				~ ~ ~ ~	<u> </u>
3373-1	•	Manufactured	(No	ST381	120743	100	9 9 Each	27.0000	_ _ 1	4 2	_	DAS 30	
FD3373-1*		Manufactured	NO			100	Each	27.0000	** _			30 9-89	14/06
1				Location		Loc	<u> </u>	Loc Code					
				GA ST040	105986		21 21 6		_	2	-		
3393-1		Manufactured	No		74862	100	6 Each	1.0000	 _ 1	2	- - 1069	§	
D3393-1* attery Lock Casing		ivianuiaciuieu	110			100	Daoli	1.0000	** _		106 6 380 8868	•	14/06
				Location		Loc	Otv	Loc Code					

DQA:			Date:			_							
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Work Orde	er: -					,	1		custom .	C	1	\&/a+a= a+[
Dom N	۱,					Rework			Skid-tube	Crosstube Small Fab	Dro	Water Jet	Engineering
Part N	NO					Scrap Use-as-is			Machining noforming	Finishing	4	d. Eng. Coor. e/Packaging	Quality Other
NCR N	NCR No.			Suspected Unapproved		Hien	~ 	Composite	Nec/3tol	Supplier			
, were	•••-					Suspected Onapproved	j		carge rab	composite_	1	oupplie! [
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Material													
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Supplier	Щ												
Training	Н	22 ii 187											
Transport	\dashv	46 -#₁											
Unapproved						***	<u> </u>	UTCA	TECORY		L		
l andia						General	FA	OLI CA	TEGORY	,			·
Landir		ear Bending				Bend		lealia/E	Program		Outside Dim	ensions [Pressure/Forced
	-	Centre No	nt Concer	ntric	┢	BOM/Route	-	Grain	Togram	-	Over/Under	- F	Set-up
	-	Cracks	or concer	itiic		Broken/Damage/Defect	\vdash	Hardwa	are		Part Incorred	F	Temperature/Cure
}	-	Crimp/Kir	sk/Rinnle	/Wave	-	Burrs			ion Incomplete/Unq	ualified	Part Lost/Mi		Weld
	_	Cuffs	riks 11.4 Trible (o)	,		Contamination		4 `	tions Incomplete/Un		Part Moved		Wrong Stock Pulled
ľ	$\boldsymbol{\vdash}$	Crushing				Countersink		4	gned/off center		Positioned V	۔ Vrong	
	Heat Treat					Cut Too Short		Mislabe			Power Loss/		Other
	Inspection Strip in Tube					Drawing		Misrea	d				
	Marks/Chatter					Drill Holes		Off-set					
	Turning Sequence					Finish		Out of	Calibration				
	Wave/Twist in Tube					Fit/Function		Out of	Sequence				

April-24-14 9:09:57 AM

Work Order ID: 117040

117040 *D3393-041*

D3393-041 Parent Item:

Parent Item Name: Battery Lock

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 2.00

Required Qty: 2.00 DAS

30

D3393-3

Manufactured

140

Each 20.0000

**

9-89

D3393-3

Cam Llock Shaft

Location	Loc Oty	Loc Code	
ST041	20		-
101110	1		_
108529	7	•	
109126	12		

DQA:		<u> </u>	Date:		·									TAART
						WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE				_	AEROSPACE
QA Closed:			Date:				-			W	ork Order up	date only		
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	-	Cracks	ok/Dinnla	/\4/2\10	-	Burrs	┝	4	are ion Incomplete/Unqualifie	,d	Part Lost/Mi	-	_	Weld
		Crimp/Kink/Ripple/Wave				Contamination	⊢	1 '	tions Incomplete/Unclear	·	Part Moved	331118	—	Wrong Stock Pulled
	-	Cuffs Crushing				Countersink	\vdash	-1	gned/off center		Positioned V	L Vrong	—)`	Wong Stock Funcu
	-	crusning Heat Trea	1+		-	Cut Too Short	\vdash	Mislabe	=		Power Loss/		\neg	Other
		nspection		Tube	\vdash	Drawing	-	Misrea			1. 2 2333,	o- L		
	-	Marks/Ch	•	Tube		Drill Holes	\vdash	Off-set						-
		Turning S				Finish	\vdash	4	Calibration		-			
	-	Wave/Tw				Fit/Function		4	Sequence					